

Date: Thursday, 26/06/2008 9:57:37 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	X-TUBE AS 350/355 HI AFT UNDER REVIEW
Job Number :	40113		
Estimate Number :	13225		
P.O. Number :		Part Number :	D350748241TRN
This Issue :	26/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-748-241 REV.D
First Issue :	/ /	Project Number :	N/A
Previous Run :	40112	Drawing Revision :	D
	Type :	Material :	
	CROSSTUBES	Due Date :	07/07/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JUD 08.06.26		
Comment :	Est Rev:A New Issue 08-03-06 DD verified by:ec Est Rev B Removed polish 08.04.02 EC verified by : DD Est Rev C Removed LPS-3 08.06.23 Ec verified by: DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6018125

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Material
 D6018-125
 2.299" OD X 2.000" ID
 Batch: B27472 B27472 a.m 08.07.10 ①

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3- File transition lines smooth.

a.m 08.07.10 ①

3.0

QC1

INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEETa.m 08.07.10 ①

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2- File transition lines smooth.

a.m 08.07.10 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/06/2008 9:57:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 40113

Part Number: D350748241TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Scribe part # as per Dwg D350-748-241

am 08-09-10 ①

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

am 08-09-10 ①

6.0

QC8

SECOND CHECK



8-7-10
AUM



Comment: SECOND CHECK

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2012

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

CLB 8/08/25
①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

8/5/09 (L)

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5/08/09/30 ②

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock in kanban rack

Location: Back HALL

RT 08-09-30

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30 JF

Job Completion



MF 08-09-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40113
Description: Crosstube Assembly (AS350/355 High Aft)		Part Number: D350-748-241
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	/			
	2.180	+0.005/-0.000	2.185	/			
	2.180	+0.005/-0.000	2.188	/			
	2.208	+0.005/-0.000	2.213	/			
	2.234	+0.005/-0.000	2.238	/			
	2.253	+0.005/-0.000	2.255	/			
	2.272	+0.005/-0.000	2.277	/			
	2.299	+0.005/-0.000	3.299	/			
	0.063	+/-0.010	0.063	/			
	4.26	+/-0.030	4.290	/			
	R0.063	+/-0.010	R0.063	/			
	R0.50	+/-0.030	R0.50	/			
SIDE B	2.240	+0.005/-0.000	2.245	/			
	2.180	+0.005/-0.000	2.185	/			
	2.180	+0.005/-0.000	2.185	/			
	2.208	+0.005/-0.000	2.213	/			
	2.234	+0.005/-0.000	2.238	/			
	2.253	+0.005/-0.000	2.255	/			
	2.272	+0.005/-0.000	2.277	/			
	2.299	+0.005/-0.000	2.299	/			
	0.063	+/-0.010	0.063	/			
	4.26	+/-0.030	4.290	/			
	R0.063	+/-0.010	R0.063	/			
	R0.50	+/-0.030	R0.50	/			
	122.70	+/-0.060	122.740	/			

Measured by: G.m	Audited by: ALM	Prototype Approval: N/A		
Date: 08.07.10	Date: 8-7-10	Date: N/A		
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	

DART**RELEASED**

06.10.31

DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

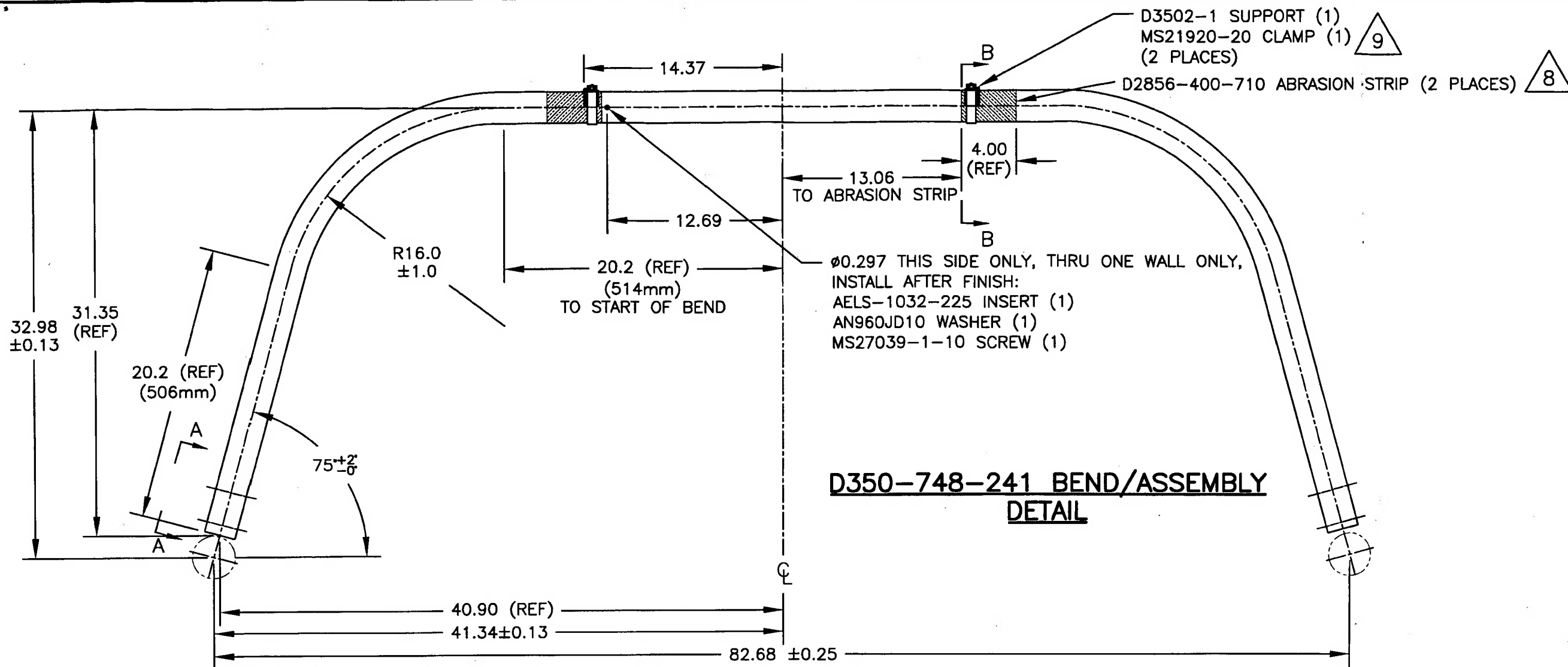
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW
07.02/16
CUFF
OK 07.02.22

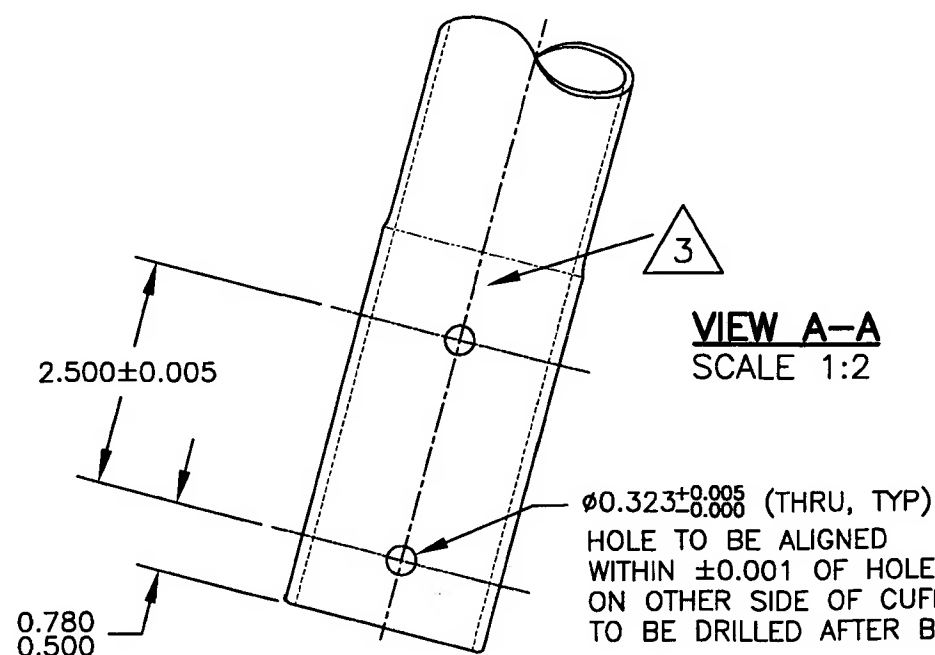
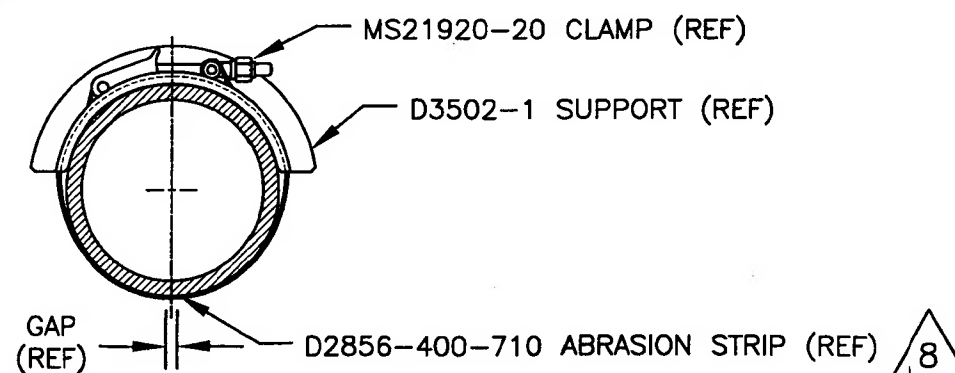
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D350-748-241 BEND/ASSEMBLY DETAIL

SECTION B-B SCALE 1:2

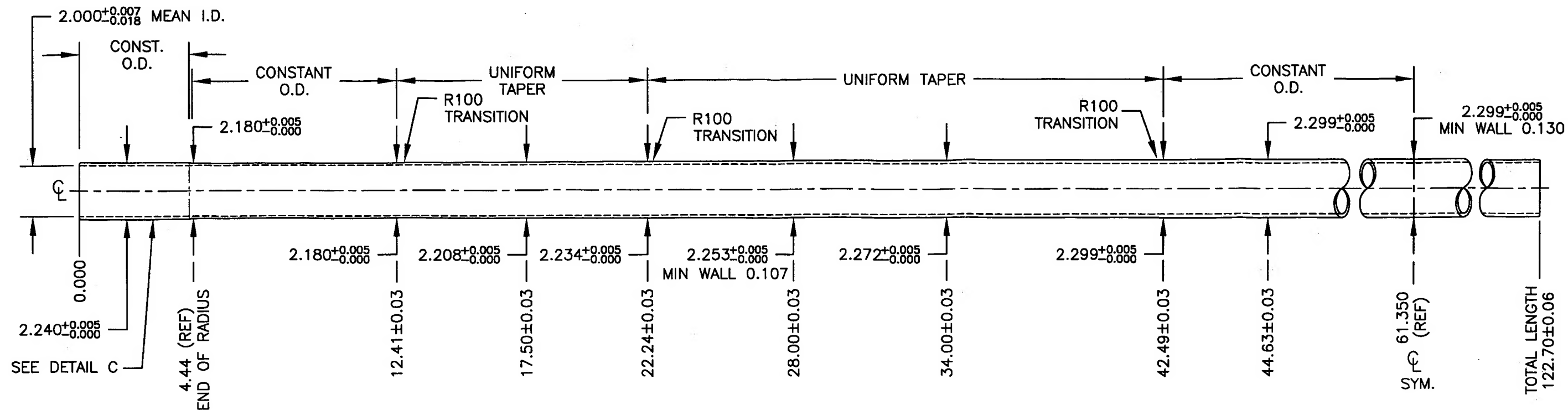


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07.02/16/18
CUFF BEND REDUCED
07.07.22

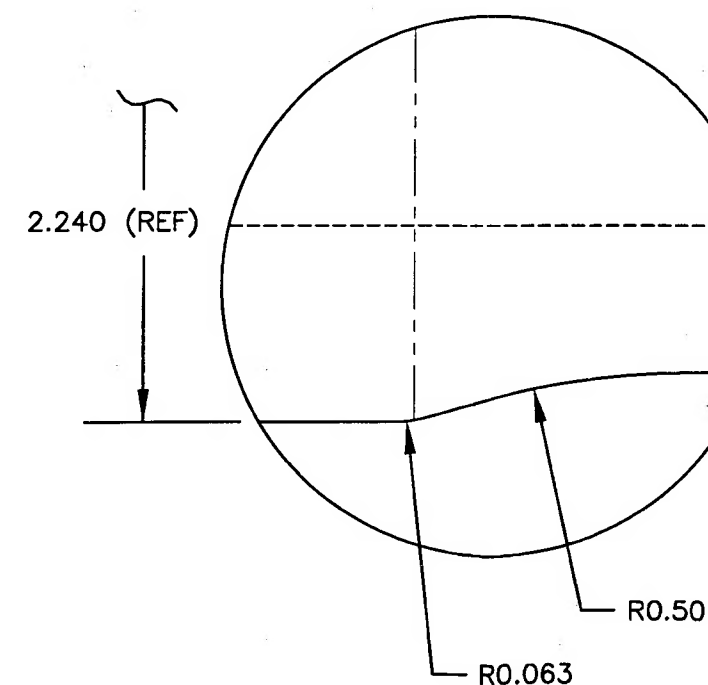
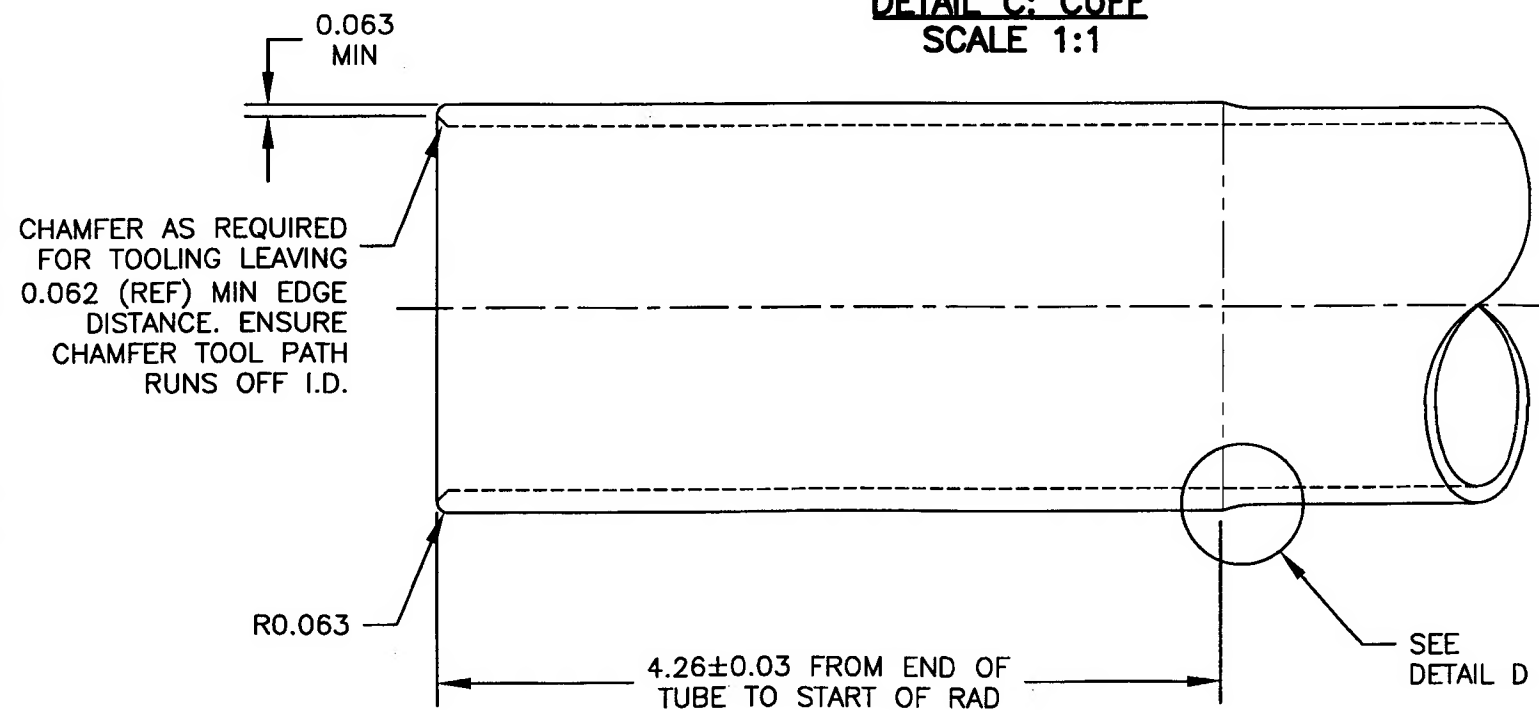
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		DATE	06.10.31			D350-748-241	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (AS 350/355 HI AFT)	1:8



D350-748-241 MACHINING DETAIL

DETAIL C: CUFF
SCALE 1:1



DETAIL D:
CUFF TRANSITION
SCALE 9:1

UNDER REVIEW
07.02/16/17
CUFF ~~REDESIGNED~~
OK 07.02.22

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	



VAC AERO

INTERNATIONAL INC.

RELEASE NOTE

GST No. : R105468102

OAK 102442-1



HEAD OFFICE

1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B

OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION

7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

09/26/2008

MM / DD / YYYY

PAGE : 1

1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/26/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00007012		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748		EA	12	12	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1D 100% HARDNESS TESTED AS PER ASTM E-18, 40-45 HRC MATERIAL: 4130</p> <p>SAND BLASTED PARTS</p> <p>1. PIECE P/N D350-748-141 B4010 1. PIECE P/N D350-748-141 B4010 1. PIECE P/N D350-748-141 B4042 1. PIECE P/N D350-748-141 B4009 1. PIECE P/N D350-748-241 B4011 1. PIECE P/N D350-748-241 B4011 1. PIECE P/N D350-748-241 B4041 1. PIECE P/N D350-748-241 B4011 4. PIECES P/N D350-748-141 B0023</p>					

100% HARDNESS TESTED

12 PCS

42/43 HRC



S
08/09/20

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Opura Robinson
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

